

wpl/2665 W/025516

Dart Aerospace Ltd.

Date: Friday, 07/07/2006 8:31:37 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MID TUBE ASSEMBLY
Job Number	: 27845		
Estimate Number	: 10469		
P.O. Number	: N/A	Part Number	: D3391023
This Issue	: 07/07/2006 S.O. No. : N/A	Drawing Number	: D3391 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: E
Previous Run	: 27639	Material	: N/A
Written By	: _____	Due Date	: 14/07/2006 Qty: 1 Um: Each
Checked & Approved By	: _____		
Comment	: Est. A 05.10.20 New Issue KJ/EC		
	: Est. B 06.02.10 ECN773 dwg rev.D EC		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001100 Skidtube Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	

2.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tube to finish length as per Dwg D3391

2-Identify as D3391-023

3-Drill pilot holes using DT8796 as per Dwg D3391

4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig

5-C'sink float bag holes as per Dwg D3391

6-Open remaining holes to Ø0.375"

7-Rmove .030" from Fwd indexing Ridge as per Dwg D3391

8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391

9-Deburr

10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.250" holes with paint marker,

11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.250" (14 holes) as per Dwg D3391 and 2 holes in section Detail "J"

012-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391

W0 25516
ATTACHED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 07/07/2006 8:31:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 27845

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

13-Open .375" holes to .438"

14-Deburr and blow out all chips from inside tube

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEB

Pick:

Qty Part Number Description Batch

1 D3389-1 Web B27656

A/R Sikaflex-241/-291 M101193

Sikaflex expire date: 06 11 01

Start: 06-07-07 Time: 08:30 am

Finish: 06-07-08 Time: 08:30 pm

RT 06 07 07

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

RT 06-07-07

WO
26516
ATTACHED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ _____ Date: 06/08/2017

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Friday, 07/07/2006 8:31:37 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 27845

Part Number: D3391023

Job Number:



Seq. #: Machine Or Operation: Description :

9.0 NAS1330C3KB116 Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 20.0000 Each(s)

Insert

Pick:

Qty	Part Number	Description	Batch
20	NAS1330C3KB116	Insert	M19349

10.0 NAS1330C3KB166 INSERT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Rivnut

Pick:

Qty	Part Number	Description	Batch
10	NAS1330C3KB166	Insert	M18308

SC 06/08/02

11.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

SC 06/08/02

12.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

06/08/02 ①

13.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

N/A.

14.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: N/A

06/08/08 ①

15.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06-08-25

06/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

1/16/2006 4:18:26 PM

Process Sheet

Customer : U-DAR001 Dart Helicopters Services
 Job Number : 25516
 Estimate Number : 10469
 P.O. Number :
 This Issue : 1/16/2006 S.O. No. :
 Prsht Rev. : NG
 First Issue : 7/1/2006 Type : LANDING GEAR
 Previous Run : 24866
 Written By :
 Checked & Approved By :
 Comment : Est. A 05.10.20 New Issue KJ/EC

Drawing Name : MID TUBE ASSEMBLY

Part Number : D3391023
 Drawing Number : D3391 REV C1
 Project Number : N/A
 Drawing Revision : C1
 Material :
 Due Date : 2/13/2006 Qty: 3 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D25001100

Skidtube Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total: 3.0000 Each(s)
 SKIDTUBE EXTRUSION

Pick:

Qty	Part Number	Description	Batch
1	D2500-1-100	Extrusion	B24593

Batch

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1-Cut tube to finish length as per Dwg D3391
- 2-Identify as D3391-023
- 3-Drill pilot holes using DT8796 as per Dwg D3391
- 4-Open float bag holes to Ø0.250" as per Dwg D3391 using DT8796D visual aid Jig
- 5-C'sink float bag holes as per Dwg D3391
- 6-Open remaining holes to Ø0.375"
- 7-Rmve .030" from Fwd indexing Ridge as per Dwg D3391
- 8-Remove indexing ridge on Fwd & Aft end of skidtube as per Dwg D3391
- 9-Deburr
- 10-Drill #30 pilot holes using wearplate Jig DT8217 Identify Ø0.208" holes with paint marker
- 11-Open wearplate holes of D3391-023 assembly detail section G-G to Ø0.208" (14 holes) as per Dwg D3391
- 12-Open wearplate holes of D3391-023 assembly detail section H-H to Ø0.250" and c'sink (20 holes) as per Dwg D3391
- 13-Open .375" holes to .438"
- 14-Deburr and blow out all chips from inside tube

250

Section J

250

257

DP 06-3-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

U-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

25516

Part Number: D3391023



j. #:

Machine Or Operation:

Description :

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 06-05-25 (1)

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

PM 06-05-25 (1)

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BE 06-05-25 (1)

6.0

D33891

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEB

Pick:

Qty Part Number Description Batch

1 D3389-1 Web

A/R

Sikaflex-241/-291

Sikaflex expire date:

Start: Time:

Finish: Time:

7.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Bond web in place as per Dwg D3391 & QSI 015.

Adhere for 12 hours)

8.0

NAS1330C3KB116

Insert



Comment: Qty.: 20.0000 Each(s)/Unit Total : 60.0000 Each(s)

Insert

Pick:

Qty Part Number Description Batch

20 NAS1330C3KB116

Insert

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: 1/16/2006 4:18:26 PM
Use: Johnston

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: MID TUBE ASSEMBLY

Job Number: 25516

Part Number: D3391023

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

NAS1330C3KB166



Comment: Qty.: 10.0000 Each(s)/Unit Total : 30.0000 Each(s)

RivnuT

Pick:

Qty Part Number

Description

Batch

10

NAS1330C3KB166

Insert

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Install inserts as per Dwg D3391

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect each insert using DT8821

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Use paint screws to mask inserts.

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

15.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries